

Date: Thursday, 7/19/2007 2:27:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 33673	
Estimate Number : 10287	
P.O. Number : <u>N/A</u>	Part Number : D32021
This Issue : 7/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3202 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : PURCHASED PARTS	Drawing Revision : B1
Previous Run : 31658	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 8/10/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: B No Longer Made In House 05-11-06 JLM	
Est Rev: C Now on Waterjet 07-04-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S032	5052-H32 .032 Sheet
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Comment: Qty.: 1.6286 sf(s)/Unit Total : 19.5426 sf(s)

5052-H32 .032 Sheet

Batch: M10 3321(9) 160470 (3)SAD 07/07/28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: B1Prog Rev: B12-Deburr if necessary →[Signature] 07/07/31SAD 07/07/28

(12)

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/28

(12)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/07/31

(12)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

[Signature]07-09-01

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 33673

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 104864



(12x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-h

07/08/03

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 07/08/07

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/08/07

(12x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/07

Job Completion



CL07108107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

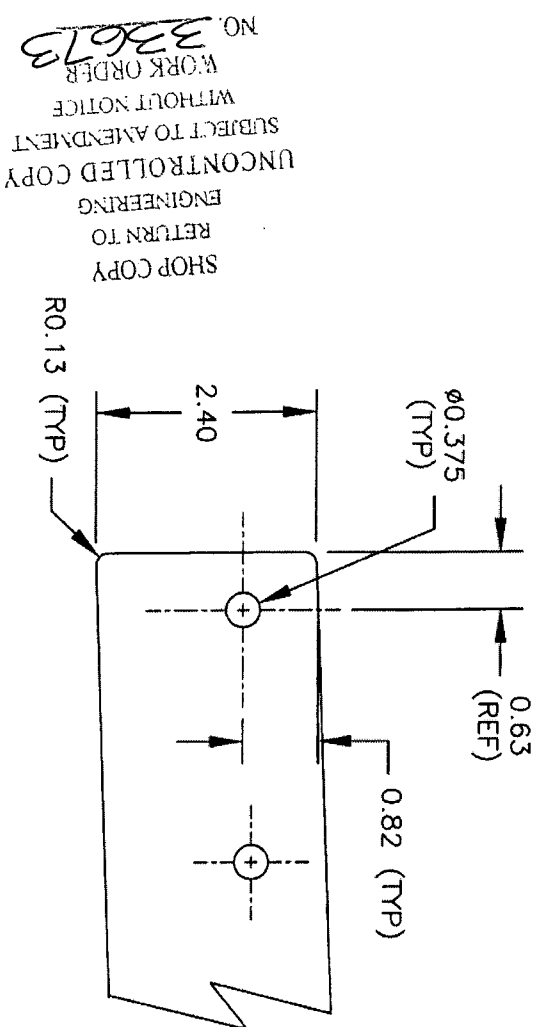
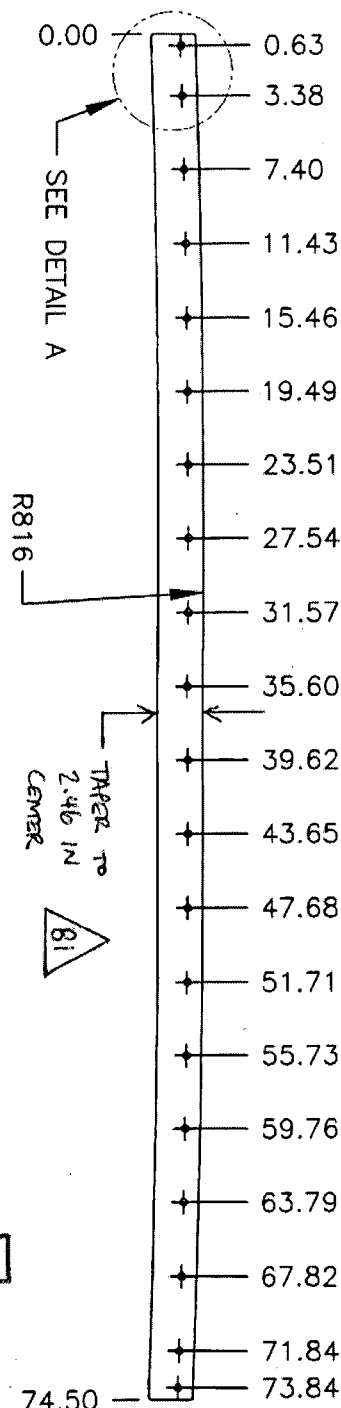
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DETAIL A
SCALE 1:2

RELEASED

03.11.07

- D3202-1 COVER**
- 1) MATERIAL: 5052-H32/H34 SHEET (90-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 33673

DESIGN BY	APPROVED	CHECKED	DATE	03.10.16	TITLE	COVER	SCALE	1:10
DRAWN BY	APPROVED	CHECKED	DATE	01.01.01	NEW ISSUE	REDESIGN; PART NOW CURVED	REV. B	
DART AEROSPACE LTD	DRAWING NO.	D3202	SHEET 1 OF 1					
HAWKESBURY, ONTARIO, CANADA								

